

Date: Monday, 11/08/2008 2:11:20 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SEAT RAIL
Job Number : 41117	
Estimate Number : 13533	
P.O. Number :	Part Number : D38081
This Issue : 11/08/2008 S.O. No. :	Drawing Number : D3808 PREL Rev. A
Prsht Rev. : NC	Project Number : N/A
First Issue : 11 Type : MACHINED PARTS	Drawing Revision : PREL Rev. A
Previous Run :	Material :
Written By : <u>JLM 08.11.</u>	Due Date : 18/08/2008 Qty: 4 Um: Each
Checked & Approved By :	
Comment : Est Rev. A New Issue 08-07-31 JLM Verified By: DD	

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B2000X01250 6061-T6 Bar 2.00 x 1.25



Comment: Qty.: 1.4175 f(s)/Unit Total: 5.6700 f(s)
 6061-T6 Bar 2.00 x 1.25
 Batch: M105411

N.A 08/08/13 (6)

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blank 16.125" long

N.A 08/08/13 (6)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

- 1- Mill as per Folio FA771 Rev. A & Dwg D3808 Rev. prelim rev. A.
- 2- Tap holes for 8-32" Helicoil
- 3- Tap holes for 3/8-16 Helicoil
- 4- Deburr per dwg D3808

25 / N.A 08/08/14 08/08/13 (6)

(810)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

25 08/08/14 (5)

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP						

Part No: D3808-1 PAR #: N/A Fault Category: Prod / Machined Parts NCR: (Yes) No DQA: D Date: 08/10/10
D3808-0411 / DS19419-011 QA: N/C Closed: A Date: 08/10/10

WORK ORDER NON-CONFORMANCE (NCR)

NCR: <u>41117</u>		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/13	3.0	Took the origin on the wrong side of the blank R.C: Operator error. Lack of Attention.	<i>[Signature]</i>	Rel'd was clear on all instructions. Scrap: replace at the 1 to the 11	H.A 08/08/13	<i>[Signature]</i> 16/08/22	<i>[Signature]</i> 16/08/22	<i>[Signature]</i> 16/08/22

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT RAIL

Job Number: 41117

Part Number: D38081

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



?

Comment: CONVENTIONAL MILLING MACHINE
1-DRILL REMAINIG HOLES

N/A Jml

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

N/A Jml

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

PH 08.08.20

ENGINEERING
APPROVAL

J.F.

08/08/15

(5)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

J.F.

08/08/15

(5)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

W/0 41238

W

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/26 JF

Job Completion



W 08.08.20

POSITIVE RECALL

EFFECTIVE 08/08/11

RELEASED

08.08.20

DART AEROSPACE LTD		Work Order: 41117
Description: Seat Rail		Part Number: D3808-1
Inspection Dwg:	Rev: Prelim A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

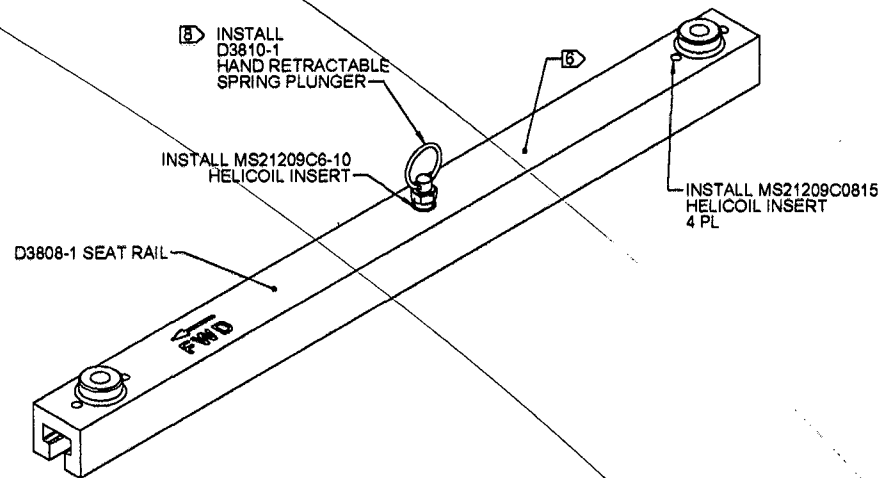
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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7.30		7.302	✓			
15.88		15.88	✓			
5.130		5.130	✓			
6.13		6.130	✓			
2.00		2.005	✓			
1.75		1.751	✓			
.550		.552	✓			
.85		.852	✓			
.780		.777	✓			
.16		.163	✓			
Ø 323 x C.S 695 x 100°		.322 x .695	✓			
Ø .172		.171	✓			
C.B 800 x .667		800 x .670	✓			
.373		.380	✓			
.140		.145	✓			
.347		.347	✓			
.350		.349	✓			
.655	+ .015 - .010	.657	✓			
.320	+ .020 - .020	.325	✓			
.720	+ .005 - .010	.721	✓			
.270	+ .030 - .020	.272	✓			
.323		.322				

Measured by: <i>JS</i>	Audited by: <i>JF</i>	Prototype Approval: <i>PH</i>
Date: 08/08/14	Date: 08/08/15	Date: 08.08.20

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

PRELIMINARY ISSUE
03-08-10 AP

QTY -041	P/N	DESCRIPTION
X	D3808-041	SEAT RAIL ASSY
1	D3808-1	SEAT RAIL
1	D3810-1	HAND RETRACTABLE SPRING PLUNGER
1	MS21209C6-10	HELI-COIL, SCREW LOCKING (RED)
4	MS21209C0815	HELI-COIL, SCREW LOCKING (RED)

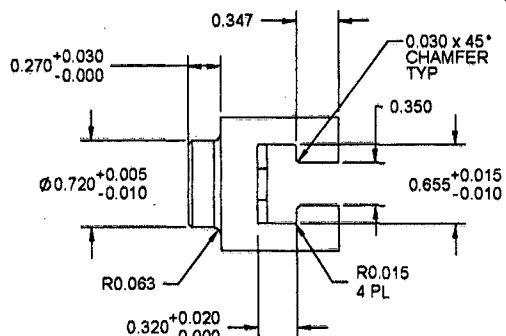
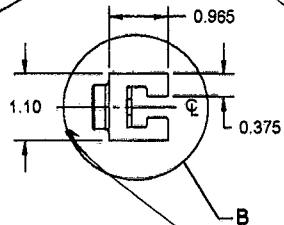
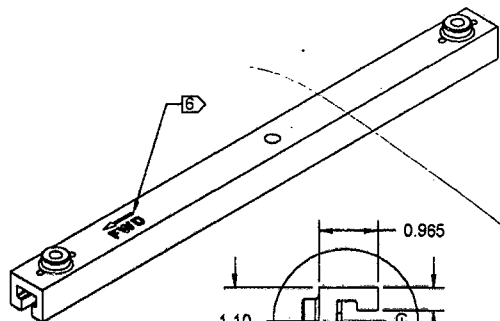


D3808-041 SEAT RAIL ASSEMBLY

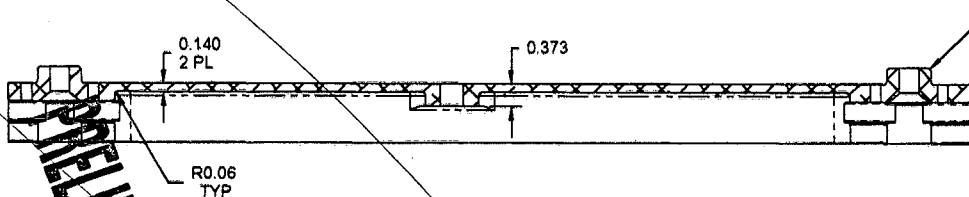
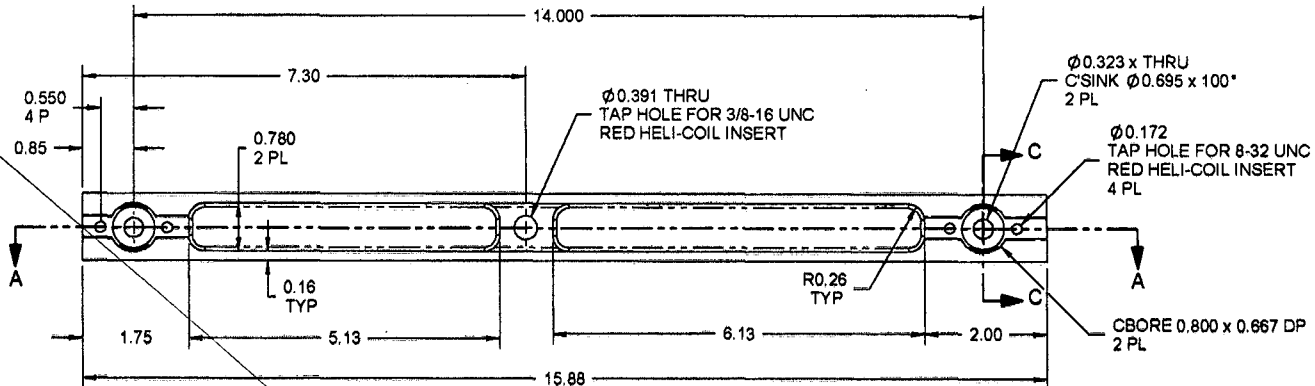
D3808-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3808-041 USING FINE POINT PERMANENT INK MARKER AS SHOWN
- 7) WEIGHT: 0.80 lbs
- 8) INSTALL D3810-1 INTO D3808-1 ONLY UNTIL NO THREADS VISIBLE ON D3810-1

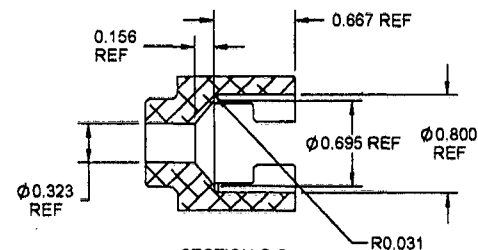
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REV.		DESCRIPTION		BY	DATE
DESIGN		RF		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		RF			
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D3808		SHEET 1 OF 2	
APPROVED		TITLE		SCALE	
DE APPR.		SEAT RAIL ASSEMBLY		NTS	
DATE		08.08.08			
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DETAIL VIEW B



SECTION A-A



SECTION C-C

PRELIMINARY ISSUE

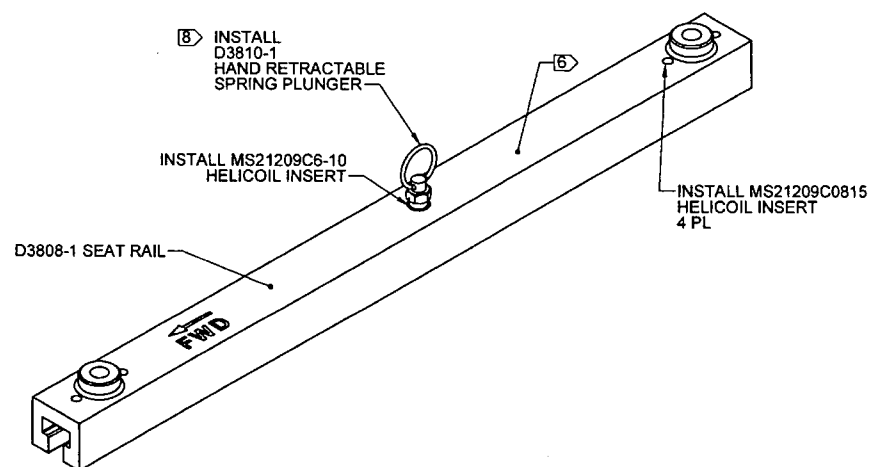
D3808-1 SEAT RAIL

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE ARROW & FWD AS SHOWN USING 0.30 HIGH LETTERS TO MAX DEPTH OF 0.005
- 7) WEIGHT: 0.768 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3808	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SEAT RAIL ASSEMBLY	NTS
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QTY -041	P/N	DESCRIPTION
X	D3808-041	SEAT RAIL ASSY
1	D3808-1	SEAT RAIL
1	D3810-1	HAND RETRACTABLE SPRING PLUNGER
1	MS21209C6-10	HELI-COIL, SCREW LOCKING (RED)
4	MS21209C0815	HELI-COIL, SCREW LOCKING (RED)



D3808-041 SEAT RAIL ASSEMBLY

RELEASED
08-09-30 1/17

D3808-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3808-041 USING FINE POINT PERMANENT INK MARKER AS SHOWN
- 7) WEIGHT: 0.80 lbs
- 8) INSTALL D3810-1 INTO D3808-1 ONLY UNTIL NO THREADS VISIBLE ON D3810-1

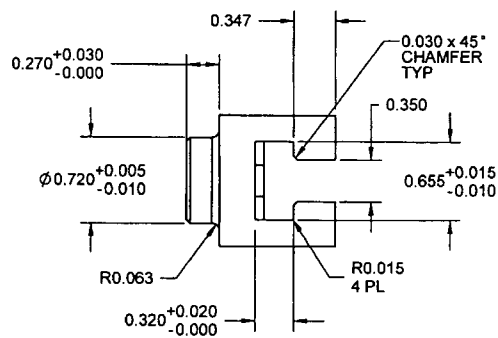
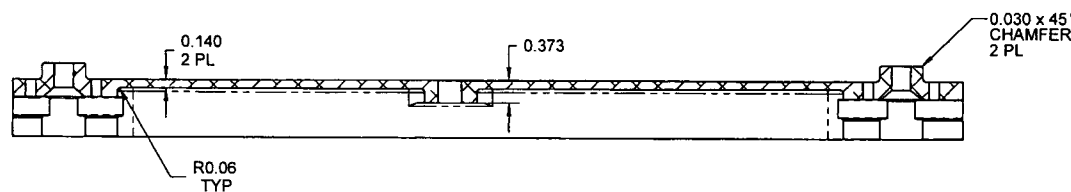
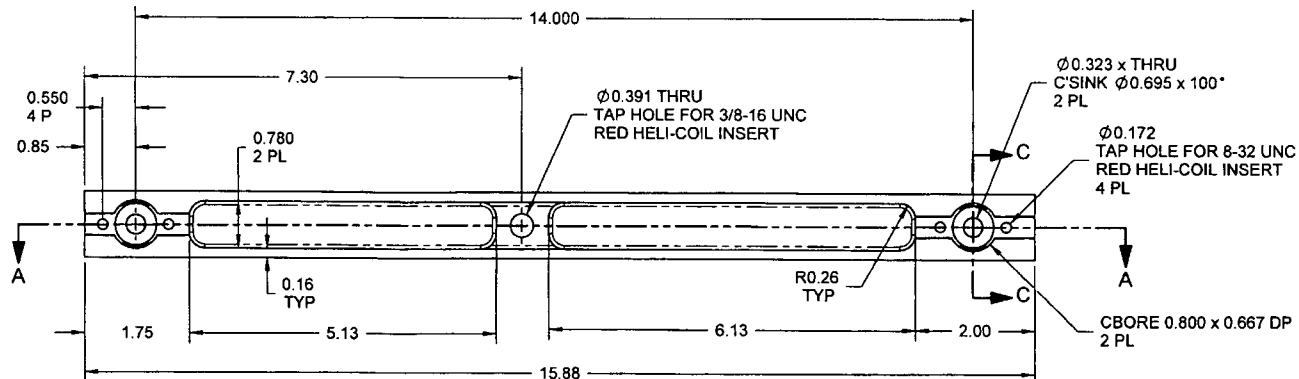
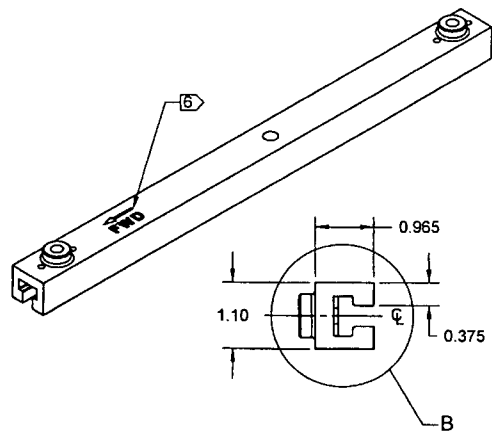
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REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.08.08		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3808** REV. A
SHEET 1 OF 2
TITLE **SEAT RAIL ASSEMBLY** SCALE NTS

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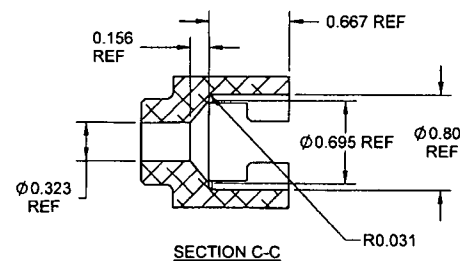
Handwritten notes:
08.10.07
41116
010



DETAIL VIEW B

SECTION A-A

D3808-1 SEAT RAIL



SECTION C-C

NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-200/8 (OR AMS 4160) OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) (REF: DART SPEC. M6061T6B)
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- 7) WEIGHT: 0.768 lbs

Handwritten signature and date: 9/13/08

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3808	REV. A
MFG. APPR.		SHEET 2 OF 2	
APPROVED		TITLE SEAT RAIL ASSEMBLY	SCALE
DE APPR.		NTS	
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